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D4956-23

Job Sheet 195815



Part No: D4956-23

Job Qty: 10 pcs ^{17 DAS} _{21 9-89}

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/2/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		7/2/19	0.00	2.77	Waterjet - Flow		219/07/29
120	QC 8	10 pcs		7/2/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	10 pcs		7/2/19	0.15	0.45	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		

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				B4B	
140 QC 5	10 pcs	7/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 4-1-Assembly-B4B	10 pcs	7/2/19	0.00 0.97	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 3	10 pcs	7/2/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	10 pcs	7/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002 42 14.8.14
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	10 pcs	7/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 100 - (Waterjet - Flow)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Assemble as per dwg)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	12.5000 sf (1.25 ea)	100-Waterjet - Flow - 1	5175010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	13	241	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740		
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490		
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740		
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130		
10	Wearshoe	30.530Inches ± 0.010	30.540 30.520		
11	Wearshoe	35.920Inches ± 0.010	35.930 35.910		
12	Wearshoe	41.310Inches ± 0.010	41.320 41.300		
13	Wearshoe	46.700Inches ± 0.010	46.710 46.690		
14	Wearshoe	50.200Inches ± 0.010	50.210 50.190		
15	Wearshoe	54.850Inches ± 0.010	54.860 54.840		
16	Wearshoe	56.850Inches ± 0.030	56.880 56.820		
17	Wearshoe	6.000Inches ± 0.030	6.030 5.970		
18	Wearshoe	14.000Inches ± 0.030	14.030 13.970		
19	Wearshoe	22.000Inches ± 0.030	22.030 21.970		
20	Wearshoe	30.000Inches ± 0.030	30.030 29.970		
21	Wearshoe	38.000Inches ± 0.030	38.030 37.970		
22	Wearshoe	45.000Inches ± 0.030	45.030 44.970		
23	Wearshoe	54.000Inches ± 0.030	54.030 53.970		

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Container No: S201348



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Part: D4956-23

Job No: 195815

Serial No/Batch: S201348

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/29/19